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ABSTRACT

A tool selection method, for a machine tool,
comprising the steps of identifying the maximum tip
5 distance (D2) of a currently selected tool (141), a next
designated tool (142) and an intermediate tool (143)
disposed therebetween; moving a tool rest (10) in the
+(plus)X-axis direction after a machining by the
currently selected tool (141) is completed until the tip
10 of the currently selected tool (141) is spaced from a
workpiece (W) along the X-axis by a distance provided by
adding a clearance distance (E) to a difference between
the maximum tip distance (D2) and the tip distance (D3)
of the currently selected tool (141); moving the tool
15 rest (10) in the +(plus)Y-axis direction until the tip of
the next designated tool (142) is aligned with the
rotation center axis (12a) of the workpiece (W) in the X-
axis direction; and moving the tool rest (10) in the -
(minus)X-axis direction.